

Work Order ID 75215***75215***

Page 1

October-19-11 10:31:14 AM

Item ID: D412-698-023

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Automatic Door Opener, LH/RH

Start Date: 19/10/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN D412-698	Rev E
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-698-023

CHG002

S u l u l 14

JG Cor MLT 11-11-7

110

0.00

110

Pick Kit

Packaging

Memo

0.00

Packaging

11/11/14 SP (60)

120

0.00

120

QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

S u l u l 14

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-023								
	Location: <u>10</u>								
	PPP Rev: <u>B</u>								
140									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/11/14
(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 75215

75215

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 07-07-12 JLM

IPP rev B ecn 1207 08.07.03 EC verified by:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN960JD516L

NAS1149D0516J

Purchased

No

120

Each

0.0000

2

12

***AN960.ID516I ***

Washer

D3552-11

Manufactured

No

120

Each

6.0000

1

6

D3552-11

Door Prop

Location

Loc Qty

Loc Code

ST272

6

72239

6

D3594-043

Manufactured

No

120

Each

11.0000

1

6

D3594-043

Floor Doubler Assembly, LH

Location

Loc Qty

Loc Code

ST

2

73673

2

ST234B

9

71690

9

D3594-044

Manufactured

No

120

Each

9.0000

1

6

D3594-044

Floor Doubler Assembly, RH

Location

Loc Qty

Loc Code

ST234B

9

71691

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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75215

Parent Item: D412-698-023

D412-698-023

Parent Item Name: Automatic Door Opener, LH/RH

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 6.00

Required Qty: 6.00

D3594-5

Manufactured No

120

Each

8.0000

**

D3594-5

Door Doubler

Location

Loc Qty

Loc Code

ST234A

8

71692

8

Manufactured No

120

Each

0.0000

**

D3622-1

D3622-1

Ball Stud

MS20426AD4-4

Purchased No

120

Each

1,713.000

**

MS20426AD4-4

Rivet

Location

Loc Qty

Loc Code

ST317

1713

116188

1713

Purchased No

120

Each

79.0000

**

MS21073L5

MS21073L5

Flat plate

Location

Loc Qty

Loc Code

ST302

79

117395

79

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: **E**

Date: 08.05.01

